

Date: Tuesday, 11/29/2005 7:15:54 PM
 User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : RING |
| Job Number : 25046 | |
| Estimate Number : 10858 | |
| P.O. Number : N/A | Part Number : D34075 |
| This Issue : 11/29/2005 S.O. No. : N/A | Drawing Number : D3407 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 11/29/2005 Type : MACHINED PARTS | Drawing Revision : C |
| Previous Run : N/A | Material : N/A |
| | Due Date : 12/18/2005 Qty: 10 Um: Each |
| Written By : <u>See below</u> | |
| Checked & Approved By : <u>new issue 05/11/22 JLM</u> | |
| Comment : Created By Auto Work Order | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|-----------|
| 1.0 | M174R3000 | Inventory |
|-----|-----------|-----------|



Comment: Qty.: 0.0306 f(s)/Unit Total: 0.3056 f(s)
 Material: 17-4ph SS Round Bar Ø3.000(M17-4-R3.000)
 Identify for D3407-5
 Batch: M18742

ml 05/12/11 10

Tools:

| | | |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Folio FA598 Rev: A & Dwg D3407 Rev: C

2-Deburr

ml 05/12/11 10

Tools:

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 05/12/11 10

Tools:

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

ED 05/12/11 10

Tools:

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 05/12/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:15:54 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 25046

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423

CL 05/12/12

(10)

Tools:

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/13 10

DS

05/12/13

(10)

Tools:

Job Completion

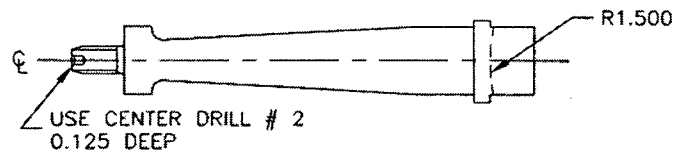


| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

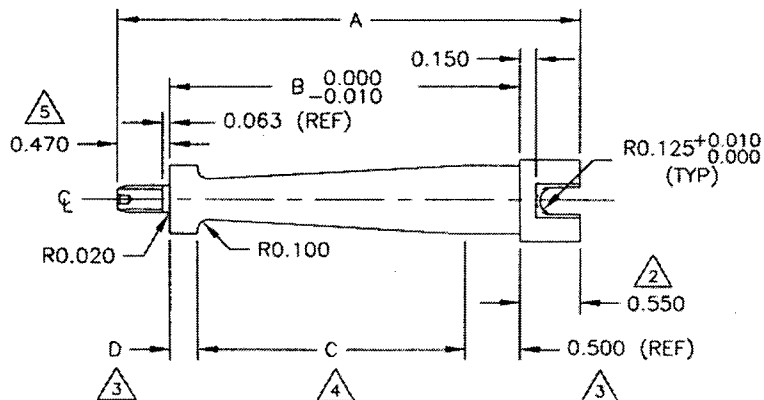
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED

05 09.12



| PART NUMBER | A | B | C | D |
|-------------|-------|-------|-------|-------|
| D3407-1 | 5.270 | 4.250 | 3.250 | 0.500 |
| D3407-3 | 4.325 | 3.305 | 2.555 | 0.250 |

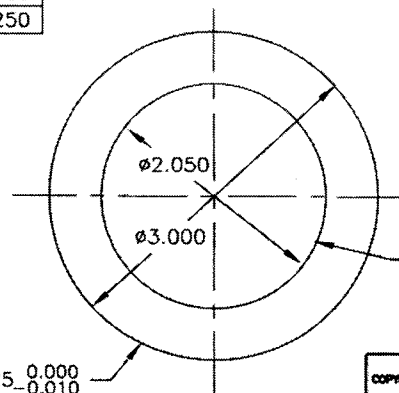
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

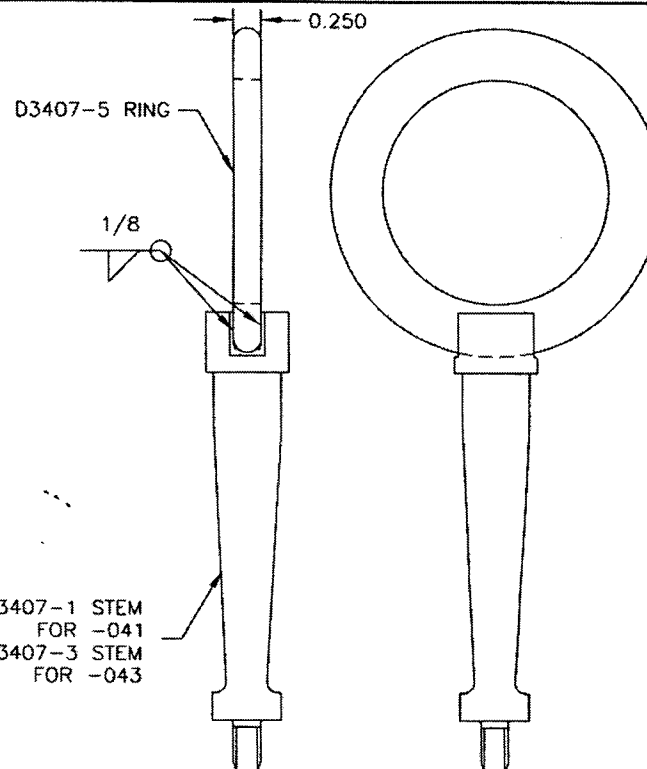
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) Ø0.750 O.D.
- 3) Ø0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING



USE D3407-1 STEM
FOR -041
USE D3407-3 STEM
FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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| | | |
|-------------|----------|-------------------------------------|
| C | 05.09.09 | -1/-3 LONGER FOR FIT W/ WASHER |
| B | 05.06.17 | UPDATE DIAMETER, THREAD CLASS ADDED |
| A | 05.03.16 | NEW ISSUE |
| DESIGN | CP | DRAWN BY CP |
| CHECKED | # | APPROVED # |
| DATE | 05.09.09 | TOW RING |
| DRAWING NO. | D3407 | REV. 2 |
| SHEET | 1 OF 1 | SCALE |

1:1

